

PARTS LIST

PRIMAAX® EX • PRIMAAX® Rear Air Suspension for Volvo Vehicles

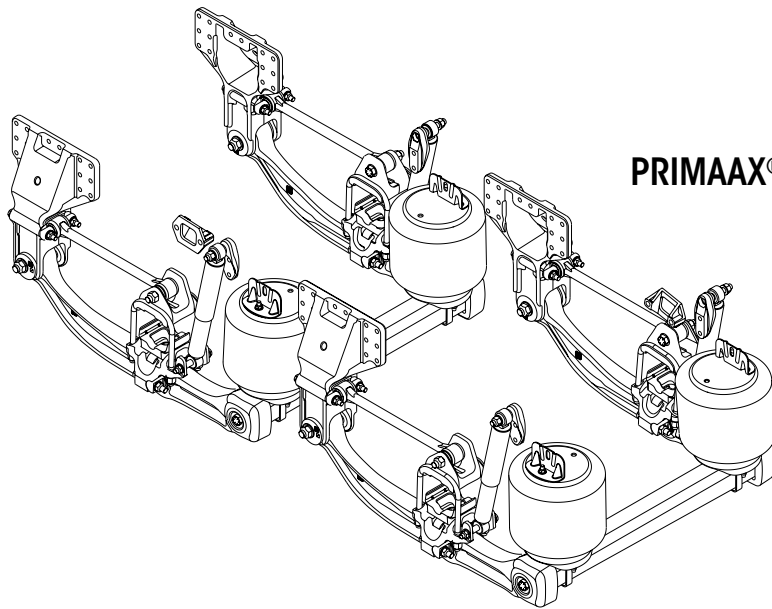
LIT NO: SP-226

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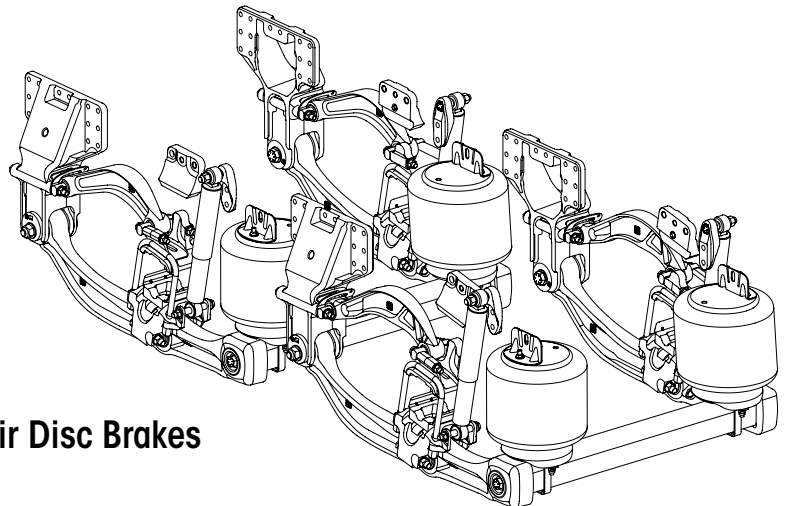
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PRIMAAX® EX with Drum Brakes

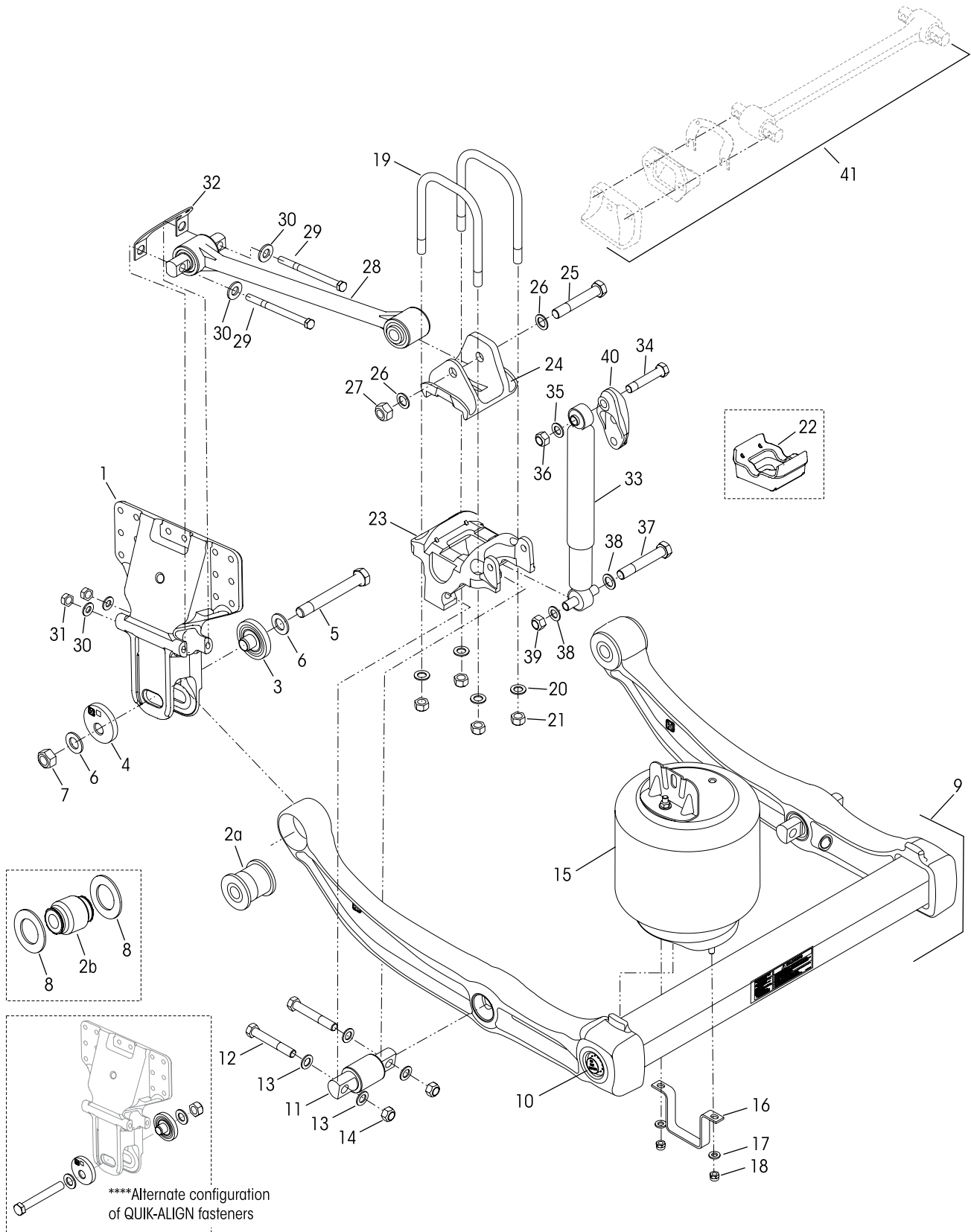


PRIMAAX® EX with Air Disc Brakes



8½" • 10" Ride Height
 Equipped with Drum Brakes

23K • 46K • 69K



****Alternate configuration
 of QUICK-ALIGN fasteners



PRIMAAX® EX for Volvo Vehicles with Drum Brakes

			VEHICLE				VEHICLE
KEY NO.	PART NO.	DESCRIPTION	QTY.	KEY NO.	PART NO.	DESCRIPTION	QTY.
1	67222-000	Frame Hanger	4	19		*3/4"-16 UNF Square U-bolt	8
		Pivot Bushing Service Kit		a		10 1/8" Length - 8 1/2" Ride Height	
	60961-720	One Wheel End, Includes Key Nos. 2a, 3-7, 42		b		9 7/8" Length - 10" Ride Height	
	60632-020	Axle Set, Includes Key Nos. 2a, 3-7, 42			48718-501	U-bolt Fastener Kit, One Wheel End	
	60632-043	Severe-duty, Axle Set, Includes, Key Nos. 2b, 3-8, 42				Includes Key Nos. 20-21	
		QUIK-ALIGN Collar Service Kit		20		*3/4" Flat Washer	16
	60632-019	One Wheel End, Includes Key Nos. 3-7		21		*3/4"-16 UNF U-bolt Locknut	16
	60632-021	Axle Set, Includes Key Nos. 3-7		22	65139-003	Axle Spacer, 8 1/2" Ride Height Only	4
	60632-018	QUIK-ALIGN Fastener Service Kit, One Wheel End, Includes Key Nos. 5-7		23	60556-XXX	Bottom Cap, <i>See Selection Guide below</i>	4
2	a	*Heavy-duty Pivot Bushing	4			Longitudinal Torque Rod Fastener Service Kits, One Side	
	b	*Severe-duty Pivot Bushing	4		58821-012	To Top Pad, Includes Key Nos. 25-27	
3		*QUIK-ALIGN Concentric Collar	4		58821-027	To Frame Hanger, Includes Key Nos. 29-31	
4		*QUIK-ALIGN Eccentric Collar	4	24	60877-001	Top Pad, 8 1/2" Ride Height	4
5		*1"-14 UNF x 7 1/2" Hendrickson Coated Hex Bolt	4		65641-000	Top Pad, 10" Ride Height	4
6		*1" Hendrickson Coated Flat Washer	8	25		*7/8"-14 UNF-2A x 5 1/2" Hex Bolt	4
7		*1"-14 UNF Hendrickson Coated Locknut	4	26		*7/8" Flat Washer	8
8		*Confinement Washer	4	27		*7/8"-14 UNF-2B Locknut	4
9		U-Beam Assembly, Includes Key Nos. 2, 10-11		28	67274-XXX	Longitudinal Torque Rod, <i>Replaces 64981-XXX See Selection Guide below</i>	4
	67249-003	Rear	1	29		*5/8"-11 UNC x 8" Hex Bolt or **M16 x 2-6G Bolt	8
	67249-004	Front	1	30		*5/8" Flat Washer or **M16 Washer	16
10	69565-001	U-Beam Assembly Enhancement Aftermarket Service Kit, See Page 8 for contents		31		*5/8"-11 UNC Locknut or **M16 x 2-6H Locknut	8
		D-pin Bushing Service Kits, See Selection Guide		32	70240-001	Torque Rod Shim, 3.0 mm	As Req.
	34013-XXX	Single, Includes Key Nos. 11-14			70240-002	Torque Rod Shim, 1.5 mm	
	56659-XXX	Fasteners Only, Axle Set, Includes Key Nos. 12-14		33	60657-007	Shock Absorber, 8 1/2" Ride Height	4
11		*D-pin Bushing	4		60657-003	Shock Absorber, 10" Ride Height	4
12		*3/4"-16 UNF Bolt, <i>See Selection Guide below</i>	8		50754-030	Single Shock Absorber Fastener Service Kit, Includes Key Nos. 34-39	
13		*3/4" Flat Washer	16	34		*3/4"-10 UNC x 4 1/4" Upper Shock Bolt	4
14		*3/4"-16 UNF Locknut	8	35		*3/4" Flat Washer	4
		Air Spring Service Kits		36		*3/4"-10 UNC Locknut	4
	60961-230	One Wheel End, Includes Key Nos. 15-18		37		*5/8"-11 UNC X 6" Lower Shock Bolt	4
	49177-006	Single, Fasteners only, Includes Key Nos. 17-18		38		*5/8" Flat Washer	8
15	67043-002	Air Spring Assembly	4	39		*5/8"-11 UNC Locknut	4
16	60911-002	Lower Air Spring Mounting Bracket	4	40	67463-006	Upper Shock Frame Bracket	4
17		*1/2" Flat Washer	8	41		**Transverse Torque Rod Assembly	2
18		*1/2"-13 UNC Locknut	8	42	70867-001	P-80 Lubricant - 10 ml (Not Shown) Per Bushing	1
		U-bolt Service Kit, One Wheel End, Includes Kit No. 48718-501			Not Shown	**Height Control Valve and Linkage Assembly	1
	91430-041	8 1/2" Ride Height, Includes Key Nos. 19a					
	91430-044	10" Ride Height, Includes Key Nos. 19b					

■ Selection Guide

	◆Pinion Angle		Key No. 12			Key No. 23	Key No. 28
	8 1/2" Ride Height	10" Ride Height	D-pin Bolt Length	D-pin Bushing Service Kit No.	D-pin Fasteners Service Kit No.	Bottom Cap Part No.	◆◆Longitudinal Torque Rod Part No.
FRONT	2.9°	2.9°	4 3/4"	34013-117	56659-012	60556-025	67274-530
	6.0°	6.1°	5 1/4"	34013-201	56659-014	60556-060	
	7.9°	8.2°	5"	34013-107	56659-009	60556-120	67274-550
REAR	10.3°	9.8°	4 3/4"	34013-117	56659-012	60556-100	67274-575
	10.7°	10.2°				60556-105	
	11.2°	10.7°				60556-110	
	11.6°	11.2°				60556-115	
	12.1°	11.6°	5"	34013-107	56659-009	60556-120	
	13.0°	12.6°	5 1/4"	34013-201	56659-014	60556-130	
13.4°	13.1°	60556-135					

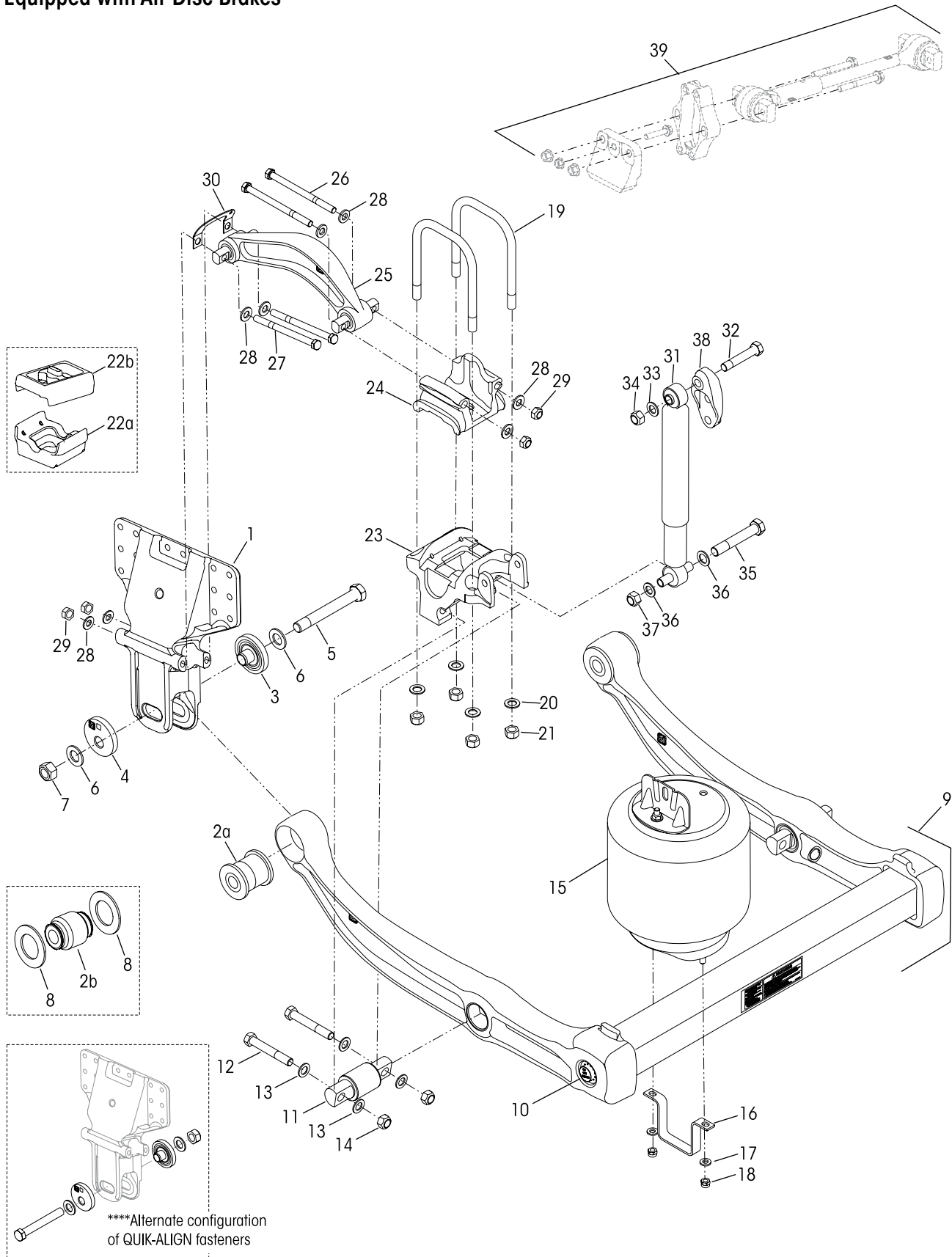
◆ Measured with QUIK-ALIGN pinion set at neutral position (12 O'Clock)

◆◆ Torque rod bushings are non-serviceable, replacement requires complete torque rod assembly with bushings.

8½" • 10" Ride Height

23K • 46K • 69K

Equipped with Air Disc Brakes





PRIMAAX® EX for Volvo Vehicles with Air Disc Brakes

KEY NO.	PART NO.	DESCRIPTION	VEHICLE QTY.	KEY NO.	PART NO.	DESCRIPTION	VEHICLE QTY.
1	67222-002	Frame Hanger	4	19		*3/4"-16 UNF Square U-bolt	8
	60961-720	Pivot Bushing Service Kit		a		10 9/16" - 8 1/2" Ride Height	
	60632-020	One Wheel End, Includes Key Nos. 2a, 3-7, 40		b		9 7/8" - 10" Ride Height	
	60632-043	Axle Set, Includes Key Nos. 2a, 3-7, 40			48718-501	U-bolt Fastener Kit, One Wheel End	
		Severe-duty, Axle Set, Includes Key Nos. 2b, 3-8, 40				Includes Key Nos. 20-21	
	60632-019	QUIK-ALIGN Collar Service Kit , Includes Key Nos. 3-7		20		*3/4" Flat Washer	16
	60632-021	One Wheel End		21		*3/4"-16 UNF U-bolt Locknut	16
	60632-018	Axle Set		22		Axle Spacer	4
		QUIK-ALIGN Fastener Service Kit, One Wheel End , Includes Key Nos. 5-7		a	65139-003	8 1/2" Ride Height, Lower	
2	a	*Heavy-duty Pivot Bushing	4	b	76960-001	10" Ride Height, Upper	
	b	*Severe-duty Pivot Bushing	4	23	60556-XXX	Bottom Cap, <i>See Selection Guide below</i>	4
3		*QUIK-ALIGN Concentric Collar	4	24	76961-000	Top Pad	4
4		*QUIK-ALIGN Eccentric Collar	4	25		Longitudinal Torque Rod, <i>See Selection Guide</i>	4
5		*1"-14 UNF x 7 1/2" Hendrickson Coated Hex Bolt	4			Longitudinal Torque Rod Fastener Service Kits, One Side	
6		*1" Hendrickson Coated Flat Washer	8		49176-060	To Top Pad, Includes Key Nos. 26, 28-29	
7		*1"-14 UNF Hendrickson Coated Locknut	4		49176-050	To Frame Hanger, Includes Key Nos. 27-29	
8		*Confinement Washer	4	26		*5/8"-11 UNC x 5 1/2" Hex Bolt	8
9		U-Beam Assembly, Includes Key Nos. 2, 10-11		27		*5/8"-11 UNC x 10 1/2" Hex Bolt	8
	67249-003	Rear	1			**M16 x 2-6G Bolt	
	67249-004	Front	1	28		*5/8" Flat Washer	32
10	69565-001	U-Beam Assembly Enhancement Aftermarket Service Kit , <i>See Page 8 for contents</i>				**M16 Washer	
		D-pin Bushing Service Kits , <i>See Selection Guide</i>		29		*5/8"-11 UNC Locknut	16
	34013-XXX	Single, Includes Key Nos. 11-14				**M16 x 2-6H Locknut	
	56659-XXX	Fasteners Only, Axle Set, Includes Key Nos. 12-14		30	70240-001	Torque Rod Shim, 3.0 mm, <i>See Selection Guide</i>	
11		*D-pin Bushing	4		70240-002	Torque Rod Shim, 1.5 mm	
12		*3/4"-16 UNF Bolt, <i>See Selection Guide below</i>	8	31	60657-007	Shock Absorber	4
13		*3/4" Flat Washer	16		50754-030	Single Shock Absorber Fastener Service Kit , Includes Key Nos. 32-37	
14		*3/4"-16 UNF Locknut	8	32		*3/4"-10 UNC x 4 1/4" Upper Shock Bolt	4
		Air Spring Service Kits		33		*3/4" Flat Washer	4
	60961-230	One Wheel End , Includes Key Nos. 15-18		34		*3/4"-10 UNC Locknut	4
	49177-006	Single, Fasteners only, Includes Key Nos. 17-18		35		*5/8"-11 UNC X 6" Lower Shock Bolt	4
15	67043-002	Air Spring Assembly	4	36		*5/8" Flat Washer	8
16	60911-002	Lower Air Spring Mounting Bracket	4	37		*5/8"-11 UNC Locknut	4
17		*1/2" Flat Washer	8	38	67463-006	Upper Shock Frame Bracket	4
18		*1/2"-13 UNC Locknut	8	39		**Transverse Torque Rod Assembly	2
		U-bolt Service Kit, One Wheel End , Includes Kit No. 48718-501		40	70867-001	P-80 Lubricant - 10 ml (Not Shown) Per Bushing	1
	91430-048	8 1/2" Ride Height, Includes Key Nos. 19a			Not Shown	**Height Control Valve and Linkage Assembly	1
	91430-050	10" Ride Height, Includes Key Nos. 19b					

■ Selection Guide		Key No. 12			Key No. 23	Key No. 25	Key No. 30			
◆Pinion Angle	Brake Clocking Ride Height		D-pin Bolt Length	D-pin Bushing Service Kit No.	D-pin Fasteners Service Kit No.	Bottom Cap Part No.	◆◆Longitudinal Torque Rod Part No.	Torque Rod Shims Ride Height		
	8 1/2"	10"						8 1/2"	10"	
1.5°	92°	84°	4 3/4"	34013-117	56659-012	60556-025	67219-435	3 mm	3 mm	
2.5°			5"	34013-107	56659-009	60556-035		4 mm	4 mm	
4°			5 1/2"	34013-116	56659-013	60556-845	77128-435	6 mm	5 mm	
6°	6"	34013-200	56659-024	60556-855	6 mm	6 mm				
7°	95°	90°	4 3/4"	34013-117	56659-012	60556-805	68801-205	5 mm	3.0 mm	
9°			5"	34013-107	56659-009	60556-810				4 mm
9.5°			5 1/4"	34013-201	56659-014	60556-820				6 mm
10°			5 1/2"	34013-116	56659-013	60556-825				
10.5°						60556-830				
11°						60556-835				
11.5°						60556-840				
12°				60556-845						
12.5°										

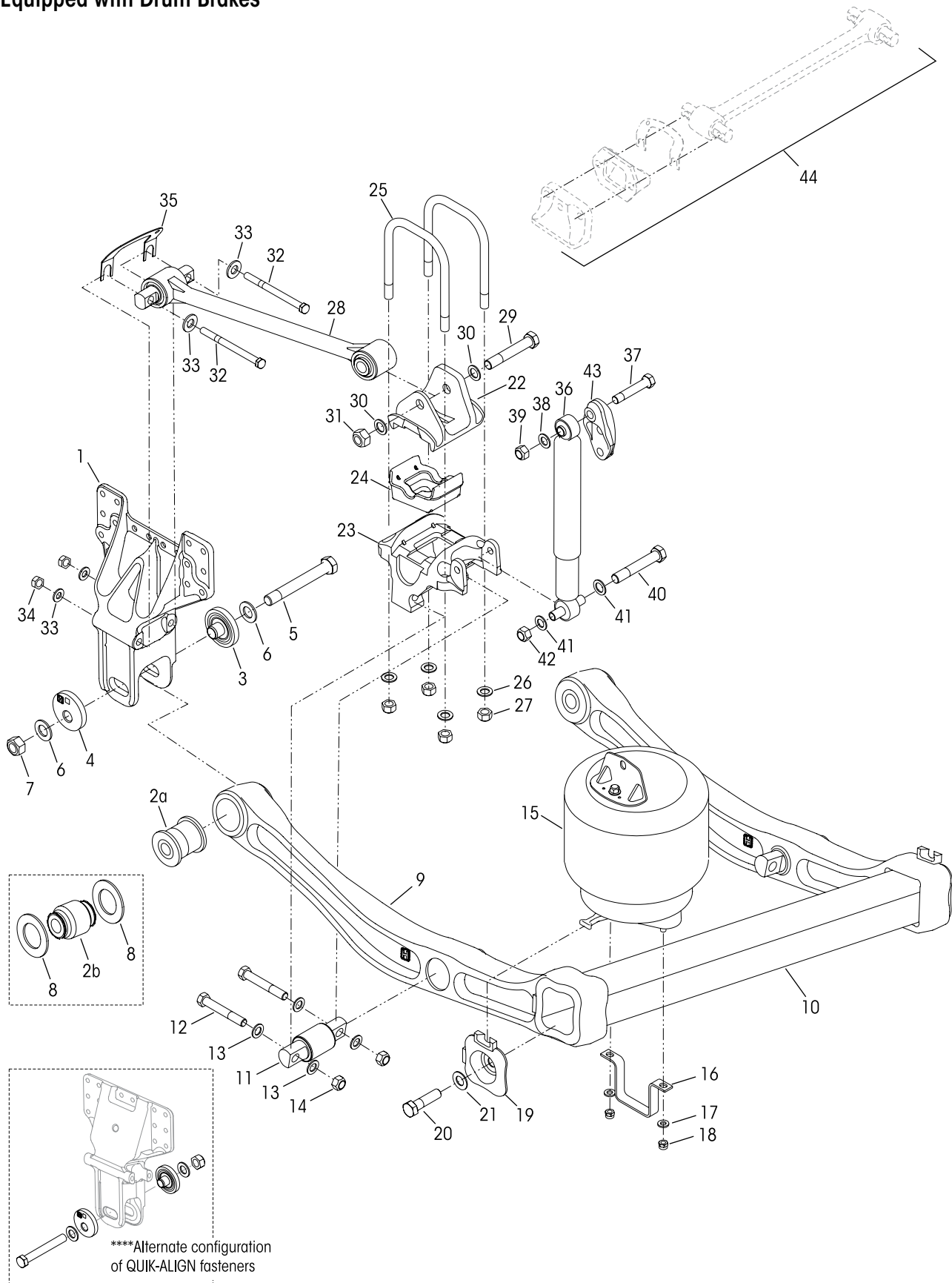
◆ Measured with QUIK-ALIGN pinion set at neutral position (12 O'Clock)

◆◆ Torque rod bushings are non-serviceable, replacement requires complete torque rod assembly with bushings.



8½" • 10" Ride Height
 Equipped with Drum Brakes

230 • 460 • 690





PRIMAAX® for Volvo Vehicles with Drum Brakes

KEY NO.	PART NO.	DESCRIPTION	VEHICLE QTY.	KEY NO.	PART NO.	DESCRIPTION	VEHICLE QTY.
1	67222-000	Frame Hanger, <i>Replaces 65702-001</i>	4	21		*7/8" Flat Washer	4
		Pivot Bushing Service Kit		22	60877-001	Top Pad	4
	60961-720	One Wheel End, Includes Key Nos. 2a, 3-7, 45		23	60556-XXX	Bottom Cap, <i>See Selection Guide on Page 3</i>	4
	60632-020	Axle Set, Includes Key Nos. 2a, 3-7, 45		24	65139-003	Axle Spacer	4
	60632-043	Severe-duty, Axle Set, Includes Key Nos. 2b, 3-8, 45			91430-041	U-bolt Service Kit, One Wheel End, Includes Key No. 25 & Kit No. 48718-501	
		QUIK-ALIGN Collar Service Kit, Includes Key Nos. 3-7		25		*3/4"-16 UNF x 10 7/8" U-bolt	8
	60632-019	One Wheel End			48718-501	U-bolt Fastener Kit, One Wheel End Includes Key Nos. 26-27	
	60632-021	Axle Set		26		*3/4" Flat Washer	16
	60632-018	QUIK-ALIGN Fastener Service Kit, One Wheel End, Includes Key Nos. 5-7		27		*3/4"-16 UNF U-bolt Locknut	16
2 a		*Heavy-duty Pivot Bushing	4	28	67274-XXX	Longitudinal Torque Rod, <i>Replaces 64981-XXX</i> <i>See Selection Guide on Page 3</i>	4
b		*Severe-duty Pivot Bushing	4			Longitudinal Rod Fastener Service Kits, One Side To Top Pad, Includes Key Nos. 29-31	
3		*QUIK-ALIGN Concentric Collar	4		58821-012	To Frame Hanger, Includes Key Nos. 32-34	
4		*QUIK-ALIGN Eccentric Collar	4	29		*7/8"-14 UNF-2A x 5 1/2" Hex Bolt	4
5		*1"-14 UNF x 7 1/2" Hendrickson Coated Hex Bolt	4	30		*7/8" Flat Washer	8
6		*1" Hendrickson Coated Flat Washer	8	31		*7/8"-14 UNF-2B Locknut	4
7		*1"-14 UNF Hendrickson Coated Locknut	4	32		*5/8"-11 UNC x 8" Hex Bolt	8
8		*Confinement Washer	4			**M16 x 2-6G Bolt	
9		***Support Beam Assembly, <i>60831-</i> , <i>see Replacement Guide below</i>		33		*5/8" Flat Washer	16
10		***Cross Tube, <i>60912-005</i> , <i>see Replacement Guide below</i>				**M16 Washer	
	34013-107	D-pin Service Kit, Single, Includes Key Nos. 11-14		34		*5/8"-11 UNC Locknut	8
11		*D-pin Bushing	4			**M16 x 2-6H Locknut	
	56659-009	D-pin Fastener Service Kit, Axle Set, Includes Key Nos. 12-14		35		Torque Rod Shim	As Req.
12		*3/4"-16 UNF x 5" Bolt	8		70240-001	3.0 mm	
13		*3/4" Flat Washer	16		70240-002	1.5 mm	
14		*3/4"-16 UNF Locknut	8	36	60657-007	Shock Absorber	4
	60961-062	Air Spring Assembly Service Kit, One Wheel End, Includes Key Nos. 15-18			50754-030	Single Shock Absorber Fastener Service Kit, Includes Key Nos. 37-42	
15	60271-002	Air Spring Assembly	4	37		*3/4"-10 UNC x 4 1/4" Upper Shock Bolt	4
16	60911-000	Lower Air Spring Mounting Bracket	4	38		*3/4" Flat Washer	4
	49177-006	Lower Air Spring Fastener Service Kit, Single, Includes Key Nos. 17-18		39		*3/4"-10 UNC Locknut	4
17		*1/2" Flat Washer	8	40		*5/8"-11 UNC X 6" Lower Shock Bolt	4
18		*1/2"-13 UNC Locknut	8	41		*5/8" Flat Washer	8
	46772-001	End Cap and Fastener Kit, Axle Set, Includes Key Nos. 19-21		42		*5/8"-11 UNC-2B Locknut	4
19		*End Cap	4	43	67463-006	Upper Shock Frame Bracket, <i>Replaces 65000-006</i>	4
20		*7/8"-9 UNC x 3 1/2" Hex Bolt	4	44		**Transverse Torque Rod Assembly	2
				45	70867-001	P-80 Lubricant - 10 ml (Not Shown)	Per Bushing 1
				Not Shown		**Height Control Valve and Linkage Assembly	1

NOTES: Quantities shown are for a tandem configuration.

* Item included in kit/assembly only, part not sold separately.

** Item required, component supplied by Vehicle Manufacturer. Hendrickson is not responsible for components not supplied by Hendrickson, for assistance with maintenance and rebuild instructions on these components see vehicle manufacturer.

*** No longer available for service, see replacement guide below. For more information, refer to Hendrickson Technical Bulletin Literature No. SEU-0229 or contact Hendrickson Tech Services.

**** Alternate configuration of the QUIK-ALIGN fasteners. The locknuts located inboard will allow additional clearance for wider tires or tires with chains. Tightening torque specification is still required ONLY on the locknut.

■ Support Beam And Cross Tube Replacement Guide

Drive Axle	DISCONTINUED		Cross Tube Part No.	NEW	COMMENTS
	Support Beam Assembly Part No.			U-Beam Assembly Replacement Kit No.	
Forward	Left Hand	Right Hand	60912-005	60961-237	Each U-Beam assembly replacement kit is intended to service the associated suspension parts on one axle. It includes two new support beam assemblies, one cross tube, two air spring assemblies, air spring fasteners, QUIK-ALIGN fasteners and D-pin fasteners.
	60831-003	60831-004			
Rear	Left Hand	Right Hand	60961-238		
	60831-001	60831-002			

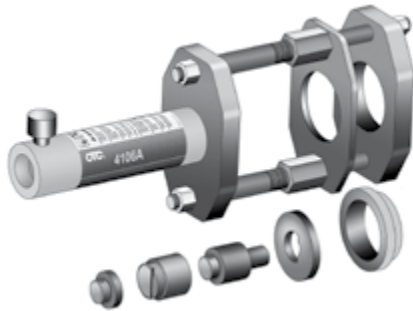


■ Special Tools

D-PIN / QUIK-ALIGN PIVOT BUSHING SERVICE TOOLS

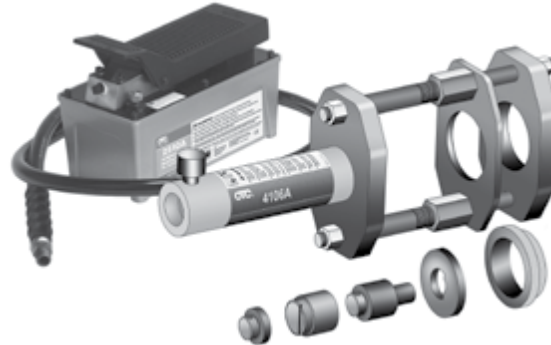
Hendrickson Part No. 66086-202

OTC Part No. 4246 Visit otctools.com



Hendrickson Part No. 66086-204

OTC Part No. 4247 Visit otctools.com



QUIK-ALIGN SOCKET TOOL

Hendrickson Part No. 66086-200

OTC Part No. 1767

Visit otctools.com



QUIK-ALIGN PIVOT BUSHING SERVICE TOOL

Hendrickson Part No. 66086-203L



■ U-Beam Assembly Aftermarket Service Kit – Axle Set

Kit No. 69565-001

PART NO.	DESCRIPTION	QTY.	In the event any service to the suspension that requires disassembly of a U-Beam Assembly (equipped with integrated end caps) the Loctite 277, tamper resistant caps, and Sikaflex 221 polyurethane sealant MUST BE properly installed to ensure components function to their highest efficiency. The enhancement components can be purchased individually or as an aftermarket service kit. * Item included in kit/assembly only, part not sold separately.
69351-000	Sikaflex 221 Polyurethane Sealant, 300 ml Tube	1	
69570-000	Loctite® 277 - 10 ml Bottle	1	
*	Tamper Resistant Cap	2	
*	7/8"-9 UNC x 3 3/4" Hex Bolt	2	
*	7/8" Hendrickson Coated Flat Washer	2	

This is a general parts list to provide directional information. Components may vary by model. Questions in regards to parts, contact Hendrickson Truck Parts at 1.866.755.5968 (Toll-free U.S. and Canada), 630.910.2800 (Outside U.S. and Canada) or e-mail: truckparts@hendrickson-intl.com.

Actual product performance may vary depending upon vehicle configuration, operation, service and other factors.

All applications must comply with applicable Hendrickson specifications and must be approved by the respective vehicle manufacturer with the vehicle in its original, as-built configuration.

Contact Hendrickson for additional details regarding specifications, applications, capacities, and operation, service and maintenance instructions.

Call Hendrickson at **1.866.755.5968** (toll-free) or **1.630.910.2800** for additional information.



www.hendrickson-intl.com

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